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# HEAT RESISTANCE PROTECTIVE EPOXY TOP COAT

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## Parsiphen 4391PH

### DESCRIPTION

\* Two component polyamide cured epoxy top coat formulated with selected special epoxy resins and polyaminoamide hardeners to cope high temperatures and harsh tensions at hot surfaces. Thanks to pigmentation with lamellar MIO pigments , it provides excellent barrier protection in high performance anti-corrosive coating systems. using high light fastness pigments ensures the weather resistance and color retention.

### USES

\* Excellent protective top coat for weather resistant multi-layer epoxy coating systems ,if it is not directly exposed to sunlight.  
\* Selected as a top coat for mild to severe industrial and marine atmospheres, when chalking due to sunlight is not a problem.

### FEATURES

\* Outstanding corrosion resistance in industrial and coastal application.  
\* Good colour retention .  
\* Good resistance to weak acids .  
\* Excellent resistance to alkalis .  
\* Heat resistance up to 160 °C in suitable paint system.  
\* Good mechanical properties .  
\* Due to MIO pigments size, surfaces might be have roughness .  
\* Limitation in selecting different shades and colours because of using MIO .  
\* Chalking and gloss reduction in exposure to sunlight is due . **See note D**

### TECHNICAL DATA

<b>Finish</b>		Semi - Flat
<b>Colour</b>		Light Gray
<b>Specific gravity ( at 20 °C , Mix )</b>		1.50 ± 0.05 ( gr/cc )
<b>Volume solid</b>		60 ± 2 %
<b>Recommended DFT</b>		50 - 100 ( mic )
<b>Heat Resistance</b>	<b>Continuous</b>	150 °C
	<b>Non- Continuous</b>	160 °C
<b>Flash point</b>		35 °C
<b>Shelf life ( at 20 °C )</b>		12 months
<b>Package</b>		20 Liters, others on request

<sup>1</sup> **Technical data and code might be changed in colored paints.**

### SURFACE PREPARATION

1 - The previous surface shall be free of any dirt , dust , oil & moisture .

### RECOMMENDED PAINT SYSTEMS

<b>P</b> : 4424PH ,7411 <sup>1</sup>	60 - 80	micron
<b>I</b> : 4211PH	100 - 200	micron
<b>T</b> : <b>4391PH</b>	80 - 100	micron

<sup>1</sup> **See note J when selecting or using zinc ethyl silicate .  
7411 needs 4252 as tie-coat or a thin mist coat of intermediate layer like 4211PH before applying main specified thickness of intermediate.**

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### APPLICATION DATA

Method	Air / Airless spray , Brush (just for inaccessible area or touch up)	
Thinner / Cleaner	T - 404	
Mixing ratio by vol	100 : 14.28	<b>Package : Base 21 kg + Hardener 3 kg</b>
Pot life ( at 20 °C )	8 hrs	

- Different thinner with different suffix maybe offered in hot and cold seasons.

#### Theoretical Coverage :

Dry film thickness (mic)	80	90	100
Coverage ( m <sup>2</sup> / lit )	7.50	6.67	6.00
Coverage ( m <sup>2</sup> / kg )	5.00	4.44	4.00

Touch dry ( 80 mic , 20 °C )	4 hrs
Fully Cured ( 80 mic , 20 °C )	7 days

- At higher dry film thickness, lower temperature and poor ventilation drying time will be longer.
- Application in closed area results in long touch & tack drying time and therefore longer minimum intervals. So sufficient air draft is required for maintaining normal application condition.

#### Recoating interval :

Surface temperature	10°C	20°C	30°C
Min. Interval ( hrs )	24	18	16
Max. Interval ( days )	7	6	5

- The maximum recoating times are for reaching the maximum chemically intercoat adhesion, but it is possible to reach a reasonable adhesion even up to few weeks. **See note E**

### APPLICATION INSTRUCTIONS :

- \* Check all equipments are dust, oil and moisture free. If needed , flush with cleaner thinner.
- \* It is recommended to use the paint with the temperature above 15°C, otherwise more thinner would be required to reach the application viscosity. Too much thinner may results in sagging, low thickness and poor hiding. In cold seasons it is recommended to keep the paint at a warmed up storage at least 3 days before use.
- \* Stir the paint well by a forced mixer before use and add the entire hardener to it and mix it again up to get a homogenous mixture.
- \* Thin the paint with defined thinner depend on required thickness & application viscosity.

#### The given data could be adjusted by applicator in practical situation by his own actual trial.

	Pressure (atm)	Orifice	Tip Range	Thinner (vol%)
Air spray	3 - 4	1.3 - 3 mm		5 - 20
Air less	6 - 7	19 - 23 mic	219 -323	5 - 10
Brush / Roller	Suitable for small areas only .			

### SURFACE TEMPERATURE

Must be at least 3°C above dew point, apply the coats when surface temperature is from 10°C to 40°C. Please consult Parsifam if the substrate temperature is lower or higher.

### SAFETY

- ▲ Due to high flammability , keep away the paints from heat , sparks and flames.
- ▲ Avoid contact the paints with eyes and skin.
- ▲ Use mask and gloves and provide suitable ventilation for the reasons of health and safety.

**REMARKS :** The information submitted in this data sheet is based on our best current knowledge and experience. The ultimate performance of this coating is quite related to performance of surface preparation, application procedure and conditions that limits our liability to the figures of submitted technical and application data .